Work Order Wednesday, June				: ( '							Page 1
	3536-25			Accept				s	etup Sta	rt	
<b>Revision ID: Item Name:</b> G	asket								Sto		
Start Date: 6/Required Date: 6/	/15/2011 /22/2011	Start Qty: 16.0 Req'd Qty: 16.0			Cust Item I	D:					
Reference:									64		
Approvals:	Process Plan	n:	Date://-0(a/5	Tooling:	Da	ite:		· · ·	un Sta		
	QC:		Date:	<b>SPC (Y/N):</b>	Da	ıte:			Sto	P	
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr									
D3536	Rev A	A									
Waterjet FLOW CNC Waterjet			per Dwg D3536 □Dwg Rev f necessary	0.00 :□Prog Rev:_	<b>A</b> □2-			<b>B</b> ((-)	6-29	60	
QC Quality Control		QC2- Inspect parts of Memo	ff machine FAI/FAIB	0.00				181	-6-29	-	<del>-</del>
120 QC		QC8- Inspect parts - :	second check	0.00 0.00 S W	de\29		(	Cuted (176	)		

Quality Control

### Work Order ID 70780

Wednesday, June 15, 2011 9:11:31 AM



Page 2

Item ID:

D3536-25

Accept

Setup Start

Stop



**Revision ID:** 

**Start Date:** 

Item Name:

Required Date: 6/22/2011

Gasket

6/15/2011

**Start Qty:** 16.00

Req'd Qty: 16.00



**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan:

QC:

Date:\_\_\_\_\_

Date:\_\_\_\_\_ **Tooling:** 

SPC (Y/N):

Date:

Date:

Run

Start



Stop

Sequence ID/ **Work Center ID** 

130

Packaging Packaging

Operation **Description** 

Identify as per dwg & Stock Location:

Set Up/ **Run Hours** 

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty.

Reject Insp.

Number Stamp

140

Quality Control

Memo

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

0.00

11/7/ CL111000104

### **Picklist Print**

Wednesday, June 15, 2011 9:11:37 AM

Work Order ID: 70780

Parent Item:

D3536-25

Parent Item Name: Gasket



Start Date: 6/15/2011

Required Date: 6/22/2011

**Start Qty: 16.00** 

Required Qty: 16.00

Com	ments:
~~	

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sḟ	466.6800	0.5956	10.58844	16,		
										B	11-6-20	l	

NEOPRENE SHEET 0.063

<b>Location</b>	Loc Qty	Loc Code		
MAT052	466.68			60)
117295	66.68			
118026	400		118090	

DART AEROSPACE LTD	Work Order:	70780
Description: Gasket	Part Number:	D3536-25
Inspection Dwg: D3536 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.80	+/-0.030	21.80	4		T 1801	
16.35	+/-0.030	16.35	>		7	
10.90	+/-0.030	(0,90	b		τ	
5.45	+/-0.030	5,45	×		τ	·
6.00	+/-0.030	6.00	≽		7	
6.75	+/-0.030	6.75	<b>×</b>		τ	
12.75	+/-0.030	15.75	to the second		7	
1.89	+/-0.030	1.885	*		V 1802	
0.30	+/-0.030	,304	ን		V	
0.30	+/-0.030	, 308	<b>&gt;</b>		V	
Ø0.19	+0.005/-0.001	,19	8		V	
						M. COM

Measured by:	1B	Audited by:	8	Prototype Approval:	N/A
Date:	11-6-29	Date:	Wo6 29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A 07	7.06.13	New Issue	KJ/JLM A	E

Dart Ac	erospace	Ltd
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W/O:			WC	ORK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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						`.			
Part No	<b>:</b>	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	<b>\</b> :	Date:	
	R	esolution:	Dispositio	n:	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	R)	<u></u> .		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section  Action Description  Chief Eng	Sign 8			Approval Chief Eng	Approval QC Inspector

P

DART

AEROSPACE PORT HADLOCK

**L** 

R C

DRAWING NO.

SHEET 1 OF

<u>6</u>

0 .25

GASKET

06.10.25

NEW ISSUE

26.65 -21.15 17.65 - 0.90 - 5.65 · 1.89 3.90 DETAIL A

D3536-11 GASKET

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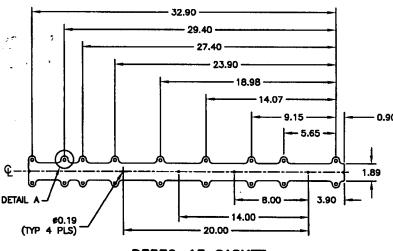
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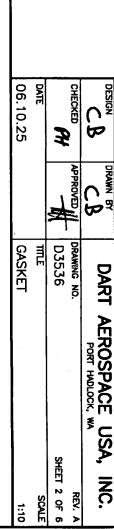
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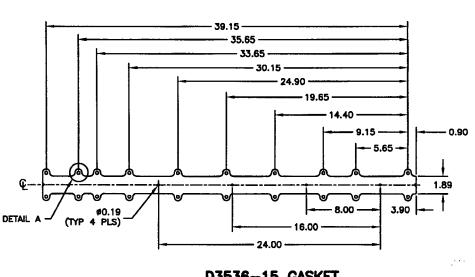
pe11-66-13



0.90 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063) DETAIL A 2) FINISH: NONE 3) PART IS SYMM PART IS SYMMETRICAL ABOUT & TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED D3536-13 GASKET ALL DIMENSIONS ARE IN INCHES IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:	•		W	ORK ORDER CHANG	FS						
DATE	STEP	PRO	OCEDURE CHA		By	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	; <u></u>	PAR #:	Fault Cate	egory:	_ NCR: Y	es N	o <b>DQ</b>	A:	_ Date: _		
Resolution:			Disposition	n:	_ QA: N/	Clos	ed:		Date: _		
NCR:		•	WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC	Corrective Action Section Initial Action Description		Section B on Sign &		Verification		Approval	Approval	
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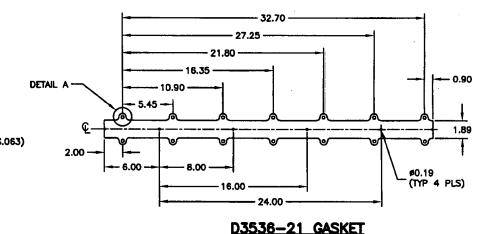




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Will Company

D3536-15 GASKET



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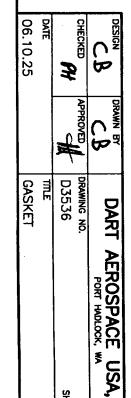
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PART IS SYMMETRICAL ABOUT & TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES
6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:			WORK ORDER CHANGES							
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
· · ·										
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Resolution:										
NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCR	)				
DATE	STEP	Description of NC		Corrective Action Section B		Verific	ation	on Approval	Approval	
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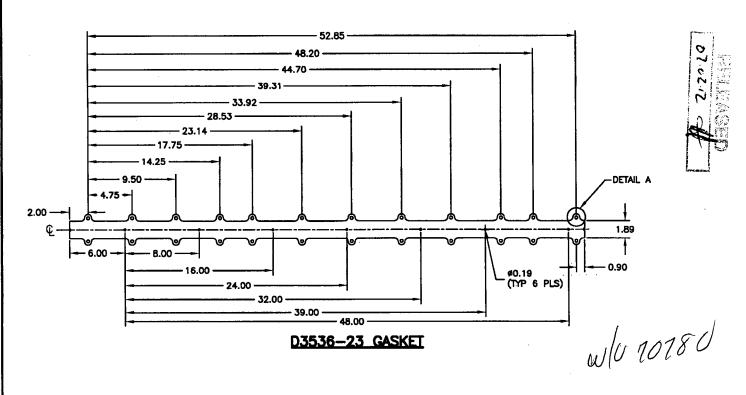
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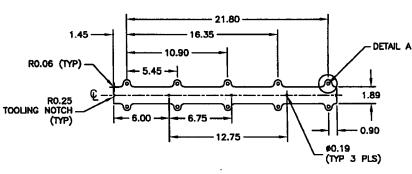
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4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES
IDENTIFY WITH DART P/N USING A WHITE FINE POINT
PERMANENT INK MARKER

7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-25 GASKET

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**PURPOSE** 

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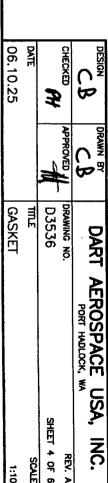
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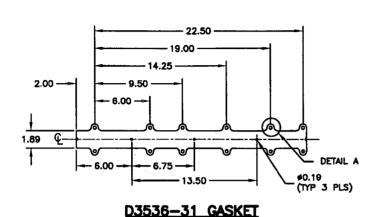
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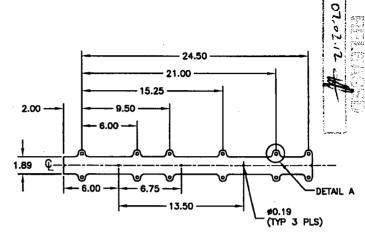
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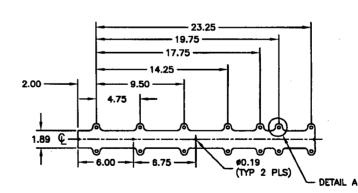
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DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	<b>Description of NC</b> Section A	Initial Action Description		Section B  Sign &		Verification Section C		Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng		Date				
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D3536-33 GASKET



D3536-35 GASKET

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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

- DUROMETER (REF DART SPEC. M-NEOBO-S

  2) FINISH: NONE

  3) PART IS SYMMETRICAL ABOUT ©

  4) TOLERANCES ARE PER DART QSI 018 UNLESS
  OTHERWISE NOTED

  5) ALL DIMENSIONS ARE IN INCHES
  6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
  PERMANENT INK MARKER

  2) SEE PAGE 6 FOR DETAILS AND SECTION
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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DATE	STEP	Description of NC	Corrective Action Section		Cian a Verificat		ation	ion Approval	Approval	
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**DETAIL A** 

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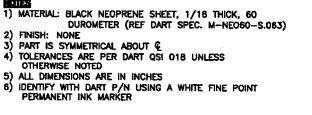
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DETAIL A



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W/O:			W	ORK ORDER CHANGE	ES					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No: PAF		PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	<b>A</b> :	Date:		
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